

Work Order ID 158120

Friday, March 10, 2017 3:42:56 PM

158120

Page 1

Item ID: D4271-027 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: End Fitting Assembly Aft Beam
Start Date: 3/15/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 3/17/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan:  Date: MAR 10 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4271	D 								
100		0.00							
100									
Small Fab	Memo	0.16							
Small Fab	Assemble as per dwg D4271 REAM HOLE AS PER DWG CUT RIVET AT 1.130" C' SINK AT .220" X100 DEG FOR HOLE OPPOSITE TO HEAD								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.01							
Quality Control									
120	Identify as per dwg & Stock Location: <u>51371</u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

Pick kit 2

DAS
6
9-89

MAR 15 2017

DAS
36
9-89

2x

17/03/20

2

DAS
36
9-89

MAR 20 2017

2

MAR 20 2017

DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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130	QC21 - Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.03							
Quality Control									

DAS
21
9-8

MAR 20 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																			
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Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐																			
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Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐																			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____																						
Misidentified ☐	☐	Past Due ☐																							

Picklist Print

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Page 1

Work Order ID: 158120

158120

Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 3/15/2017

Required Date: 3/17/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 11.07.20 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4148-3

Manufactured

No

100

Each

24.0000

1

2

DAS

6

9-89

MAR 15 2017

D4148-3

Stud Receiver, Lower

**

Location

Loc Qty

Loc Code

ST086

14

153830

2

154829

12

ST090A

10

157016

10

D4148-5

Manufactured

No

100

Each

29.0000

1

2

DAS

6

9-89

MAR 15 2017

D4148-5

Eyebolt Stud

**

Location

Loc Qty

Loc Code

ST086

29

153813

7

156477

12

156989

10

D4281-3

Manufactured

No

100

Each

10.0000

1

2

DAS

6

9-89

MAR 15 2017

D4281-3

Spacer

**

Location

Loc Qty

Loc Code

ST090

10

145996

1

156529

9

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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158120

Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 3/15/2017

Required Date: 3/17/2017

Start Qty: 2.00

Required Qty: 2.00

D4419-3 Manufactured No

100 Each 9.0000 2 4

D4419-3

Aft Support Plate

**

DAS
6
9-89

MAR 15 2017

Location

Loc Qty

Loc Code

ST097

9

145710

1

153484

2

154307

2

156933

4

AN4C13A Purchased No

100 Each 99.0000 2 4

AN4C13A

BOLT

**

DAS
9-89

MAR 15 2017

Location

Loc Qty

Loc Code

GA

4

m134754

4

OVER002

50

m136838

50

ST344

45

m136263

15

m136665

30

MS20427M4-20 Purchased No

100 Each 72.0000 1 2

MS20427M4-20

RIVET

**

17/03/22

DAS
36
9-89

Location

Loc Qty

Loc Code

GA

72

118429

72

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Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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Picklist Print

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Work Order ID: 158120

158120

Parent Item: D4271-027

D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

Start Date: 3/15/2017

Required Date: 3/17/2017

Start Qty: 2.00

Required Qty: 2.00

MS20615-4M18

Purchased

No

100

Each

264.0000

10

20

MS20615-4M18

Rivet

Location

Loc Qty

Loc Code

GA

40

m134762

40

ST306

224

m136579

24

m136835

200

DAS
6
2-89

MAR 15 2017

MS21043-4

Purchased

No

100

Each

1,015.000

2

MS21043-4

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

GA

17

m132803

17

OVER007

600

m136406

300

m136983

300

ST302

358

m136192

58

m136263

300

DAS
6
2-89

MAR 15 2017

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Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
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Parent Item: D4271-027

Parent Item Name: End Fitting Assembly Aft Beam

158120

D4271-027

Start Date: 3/15/2017

Required Date: 3/17/2017

Start Qty: 2.00

Required Qty: 2.00

NAS1149C0432R

Purchased

No

100

Each

1,900.000

4

8

NAS1149C0432R

WASHER

DAS
6
9-89

MAR 15 2017

Location

Loc Qty

Loc Code

GA

373

m134676

373

ST260a

1000

m136986

1000

ST266

527

m136182

527

6
8

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